

Work Order ID 74150

Monday, September 26, 2011 9:49:48 AM



Page 1

Item ID: D4406-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Wearplate Assembly

Start Date: 9/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: 

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4406

A

0.00

0.00

0.00

0.00

100




Waterjet


FLOW CNC Waterjet

304 . 050

Memo

1-Cut as per dwg D4406

prog rev: 

dwg rev: 

2-Deburr if required

B11-9-07

(4)

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

B11-9-07

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Required Date: 10/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Memo

0.00



Small Fab

Form as per dwg D4406

0.00

Small Fab

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/10/12/29
#10 Rev A

(4)

SP 11/09/29

(4)

5/10/12/29

(4)

Monday, September 26, 2011 9:49:48 AM

[illegible]

Stop

[illegible]

Reference:

Stop

Date:

**Insp.
Stamp**



0.00

weld wearplate as per dwg D4406

2059B-M119373 ☒ 11-11-24

0.00

[illegible]

Memo

0.00

Quality Control

0.00

[illegible]

Small Fab

Small Fab

Memo

Apply coating as per dwg D4406

Work Order ID 74150



Page 4

Monday, September 26, 2011 9:49:48 AM

Item ID: D4406-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Wearplate Assembly

Start Date: 9/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11-11-28 (4)

190

Identify as per dwg & Stock Location: FR-1

0.00



Packaging

Memo

0.00

Packaging

x4
counted &
measured
11/11/29

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/29
MF
11-11-29

Picklist Print

Monday, September 26, 2011 9:49:46 AM

Page 1

Work Order ID: 74150

Parent Item: D4406-041

Parent Item Name: Fwd Wearplate Assembly



Start Date: 9/26/2011

Required Date: 10/14/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 11.06.06 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4407-1 		Manufactured	No			150	Each	0.0000	1	4			
Bar M304S18GA 		Purchased	No			100	sf	55.5550	3.7	15.57895			
304/316 .050 Sheet													

B74151 X4.



12

11-11-21



811-9-07

Location

Loc Qty

Loc Code

MAT020

55.555

113062

0.155

116979

55.4

119032

119035

(4)

DART AEROSPACE LTD		Work Order: 74150
Description: FWD WFAIR PLATE ASSEMBLY		Part Number: D4406-041
Inspection Dwg: D4406-1 Rev: A		Page 1 of 1

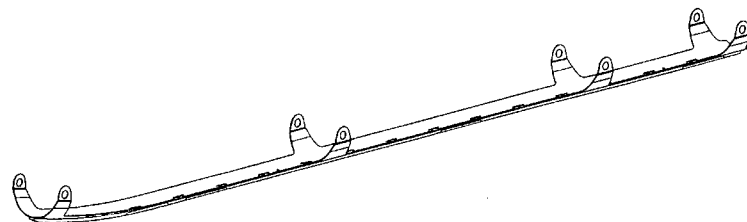
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

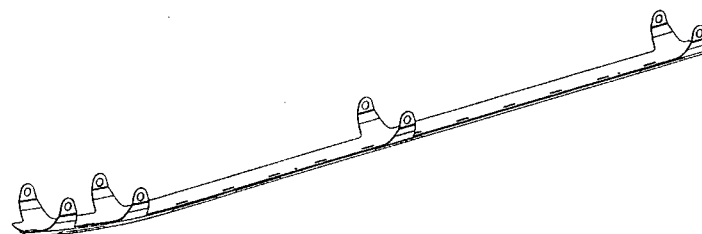
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.561	± .010	1.561	✓		V HB02	
.30	± .030	.308	✓		V	
.88	± .030	.88	✓		V	
.13	± .030	.125	✓		V	
.31	± .030	.307	✓		V	
1.77	± .030	1.777	✓		V	
7.203	± .010	7.203	✓		V	
7.80	± .030	7.803	✓		V	
3.63	± .030	3.618	✓		V	
7.00	± .030	6.998	✓		V	
4.00	± .030	3.997	✓		V	
36.00	± .030	36.00	✓		T HB01	
66.06	± .030	66.06	✓		T	
2.43	± .030	2.444	✓		V	
7.167	± .010	7.157	✓		V	
7.77	± .030	7.768	✓		V	
12.74	± .010	12.745	✓		T	
37.308	± .010	37.308	✓		T	
63.734	± .010	63.734	✓		T	
.056	± .010	.048	✓		V	

Measured by: MB	Audited by: J	Prototype Approval:
Date: 4-9-79	Date: 11/9/79	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4406-041 FWD WEARPLATE ASSY



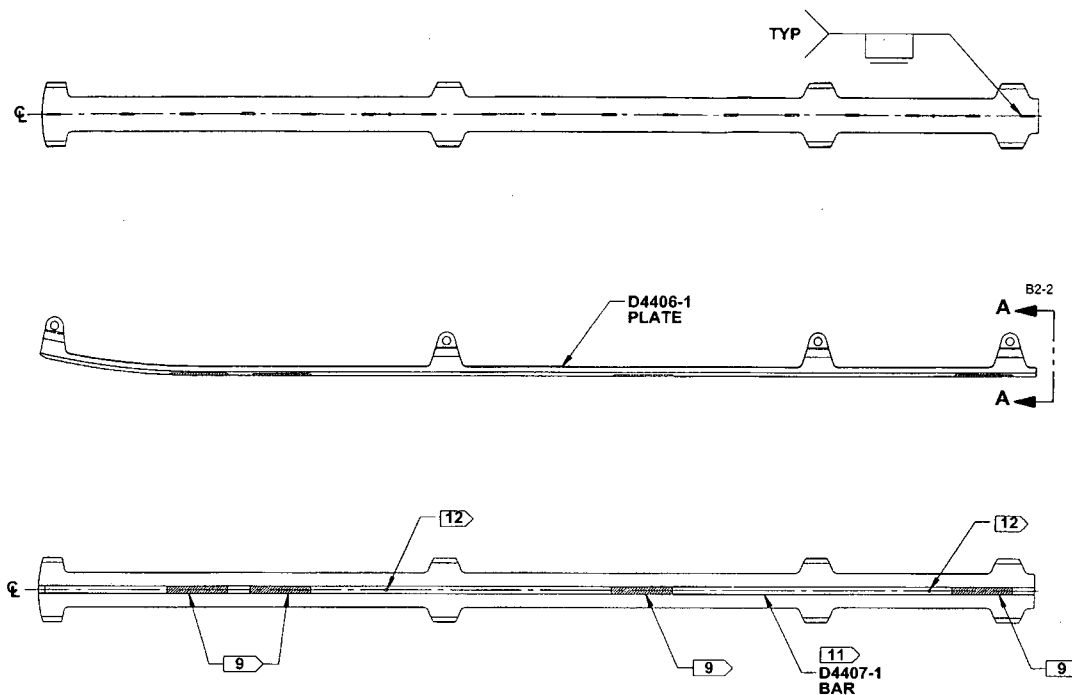
D4406-043 AFT WEARPLATE ASSY

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D4406-041	FWD WEARPLATE ASSY
2		X	D4406-043	AFT WEARPLATE ASSY
3	1		D4406-1	PLATE
4		1	D4406-3	PLATE
5	1		D4407-1	BAR
6		1	D4407-3	BAR
7	A/R	A/R	2059B	HARDCOAT
8	A/R	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2 & 3)

RELEASED
R 2011-08-29

W/074150

A	NEW ISSUE		RF	11.08.15
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>[Signature]</i>	D4406	SHEET 1 OF 6	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS	
DATE	11.08.15		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



D4406-041 FWD WEARPLATE ASSY

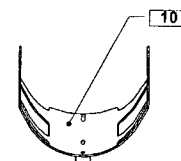
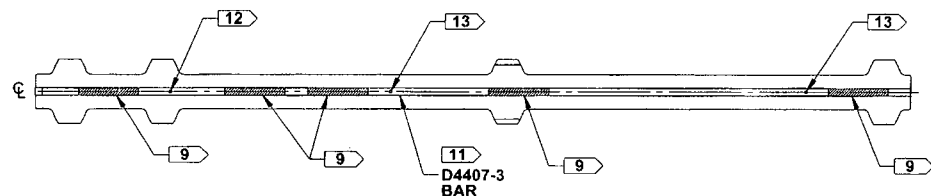
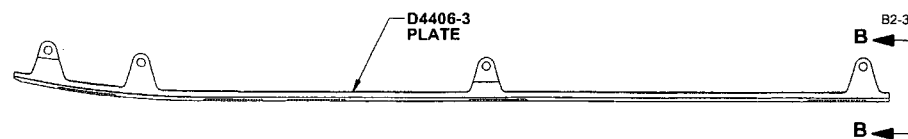
C3-2 **SECTION A-A**
SCALE 2X

RELEASED
2011-08-29
JW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 5.12 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D4407-1 BAR ON ALL 3 SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING
- 12) TRANSFER Ø0.188 HOLES FROM D4406-1 TO D4407-1

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MFG. APPR.	<i>[Signature]</i>	D4406	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
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D4406-043 AFT WEARPLATE ASSY

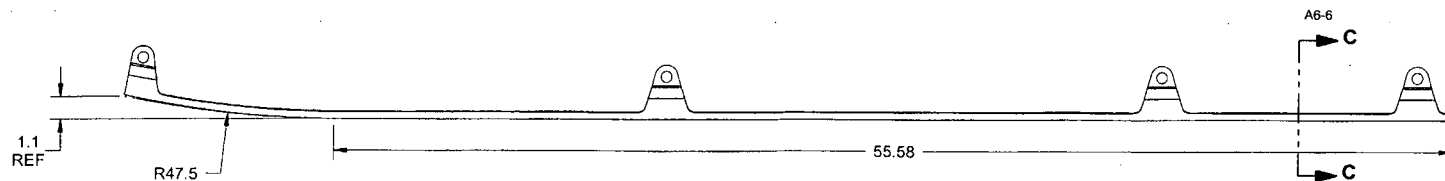
C3-3 **SECTION B-B**
SCALE 2X

RELEASE
2011-08-29
W

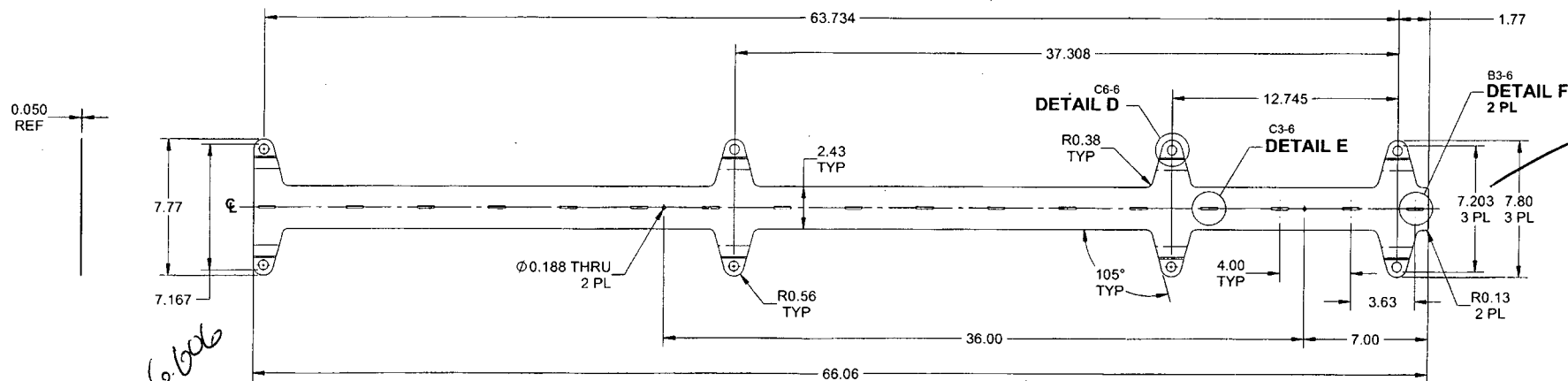
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 4.57 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D4407-3 BAR ON ALL 3 SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING
- 12) FILL TOOLING HOLE WITH WELD ONE PLACE ONLY
- 13) TRANSFER $\varnothing 0.188$ HOLES FROM D4406-3 TO D4407-3

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	RF	SHEET 3 OF 6	
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D4406-1 PLATE
(MAKE FROM D4406-1F)



D4406-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.33 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4406	REV. A
MFG. APPR.	<i>[Signature]</i>	TITLE WEARPLATE ASSY	SHEET 4 OF 6
APPROVED	<i>[Signature]</i>	SCALE	NTS
DE APPR.	<i>[Signature]</i>	DATE 11.08.15	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

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2011-08-29

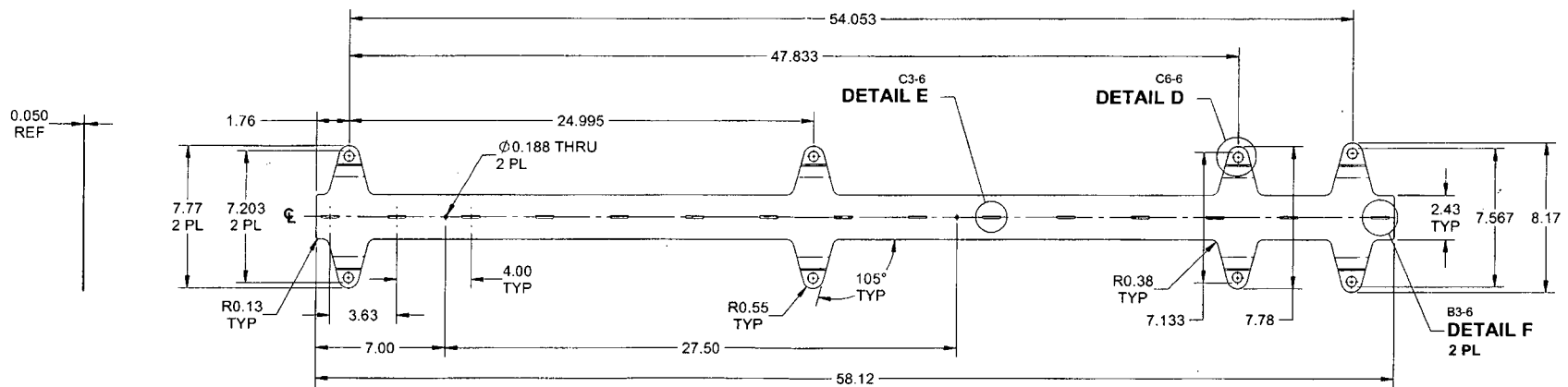
6.642

6.606

A6-6
C
C

1.4
REF

D4406-3 PLATE
(MAKE FROM D4406-3F)

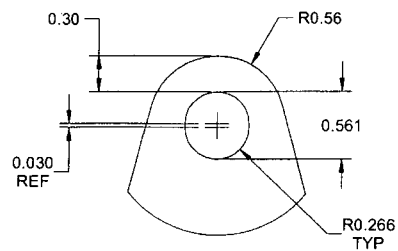


D4406-3F FLAT PATTERN

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2011-08-29
MD

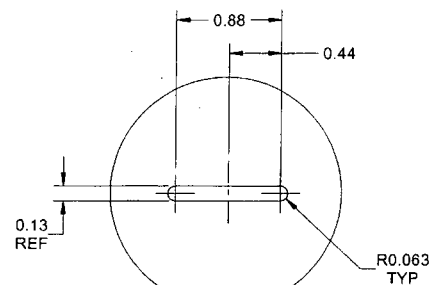
- NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
 PER AMS 5513 OR 5524
 OR ASTM A240 OR ASME SA240
 REF. DART SPEC. M304S18GA
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 2.33 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	140	DRAWING NO.	REV. A
MFG. APPR.	140	D4406	SHEET 5 OF 6
APPROVED	140	TITLE	SCALE
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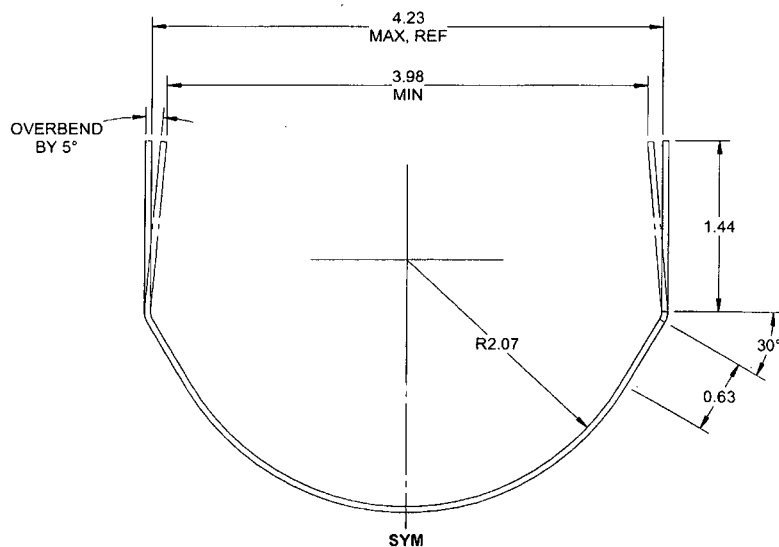
DETAIL D
SLOT DETAIL TYP
SCALE 6X

C3-4
C4-5



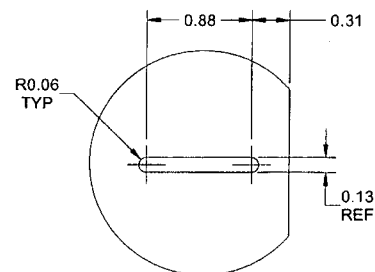
DETAIL E
SLOT DETAIL TYP
SCALE 6X

C2-4
C4-5



DETAIL C
DETAIL TYP
SCALE 6X

D2-4
D6-5



DETAIL F
SLOT DETAIL TYP
SCALE 6X

C1-4
B1-5

RELEASED
2011-08-29
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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4406	REV. A SHEET 6 OF 6
MFG. APPR.	<i>[Signature]</i>	TITLE WEARPLATE ASSY	SCALE NTS
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